

Work Order ID 58666

Thursday, May 13, 2010 11:10:03 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 0-5-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: 111675 0.00

Large Fab

Large Fab

Memo

0.00

- ✓ 1- assemble ribs , weld as per dwg D3914 using DT9607A
- ✓ 2- weld hinge (3) and Mounting brackets as per dwg D3914

inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

make sure to place mesh correctly on lid, check with label plate before tacking mesh

CPD 10.05.21

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PD 10.05.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, May 13, 2010 11:10:03 AM



Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching existing solutions, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of steps to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks identified in the plan, often in a systematic and organized manner.

5. The fifth step is to evaluate the results. This involves comparing the outcomes of the implementation against the original goals and objectives to determine the effectiveness of the solution.

6. The sixth step is to reflect on the process. This involves considering what worked well, what challenges were encountered, and what lessons can be learned for future tasks.

7. The seventh step is to communicate the findings. This involves sharing the results of the process with relevant stakeholders, providing a clear and concise summary of the work done.

8. The eighth step is to document the process. This involves creating a record of the steps taken, the resources used, and the outcomes achieved, which can be useful for future reference.

9. The ninth step is to seek feedback. This involves asking for input from others who may have insights or suggestions for improving the process.

10. The tenth step is to iterate. This involves using the feedback received to refine the process and make improvements, ensuring that the solution is as effective as possible.

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00



QC

Memo

0.00

Quality Control

0.00



Powdercoat

Memo

0.00

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3
11/12/88 START: 10:30am

Memo Temp: 320°F

FIN 11:00 AM

Wing Walk as per dwg QSI005 4.4 Batch 114402 8.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

⇒ 10/05/20

① B/L 10-5-26

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Revision ID:

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Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Insp Part Finish

0.00



QC

Memo

0.00

Quality Control

ES 10/05/26 ①

160

Identify as per dwg & Stock Location: C-A 0.00

Packaging

Memo

0.00

Packaging

W/O B58776

ES 10/05/26 ①

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/26 ①
CD 10/5/26

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 13, 2010 11:10:02 AM

Page 1

Work Order ID: 58666

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
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D2581		Manufactured	No			100	Each	36.0000	2			
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Mounting Bracket

Location

Loc Qty

Loc Code

WA

36

46086

2

51745

2

57185

9

58301

23

D2728-3

Manufactured No

140

Each

0.0000

1



Dart Logo label

D3914-1

Manufactured No

100

Each

6.0000

2



Rib

Location

Loc Qty

Loc Code

WA

6

58241

2

58585

4

D3914-7

Manufactured No

100

Each

4.0000

2



Rib

Location

Loc Qty

Loc Code

WA

4

58242

4

Pl 10-05-20

SB 10/05/25

Pl 10-05-20

B58617 - (2)

Pl 10-05-21

B58707 - (2)

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 58666

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)





Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/13/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3			
<div> <div>Location</div> <div>ST109</div> <div>57574</div> <div>ST116</div> <div>58243</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>7</div> <div>12</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>												
D4018-5  Rib		Manufactured	No			100	Each	12.0000	9			
<div> <div>Location</div> <div>WA</div> <div>58244</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
D4020-5  Mesh (350 Basket Long, Lid)		Manufactured	No			100	Each	2.0000	1			
<div> <div>Location</div> <div>WA</div> <div>58245</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
D4021-3  Data Plate		Manufactured	No			100	Each	3.0000	1			
<div> <div>Location</div> <div>WA</div> <div>56050</div> <div>58246</div> </div> <div> <div>Loc Qty</div> <div>3</div> <div>1</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>												

Pl 10-05-20

B58555 → ③

Pl 10-05-21

58977 → 9

Pl 10-05-25

B58483

Pl 10-05-20

*58616
57701 → ①*

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 13, 2010 11:10:02 AM

Page 3

Work Order ID: 58666



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010

Required Date: 5/28/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4035-041		Manufactured	No			100	Each	2.0000	1			
Lid Rib Assembly, Fwd (350 Basket)												

Location Loc Qty Loc Code

WA	2	
58192	2	

58591 → ①

D4035-043		Manufactured	No			100	Each	2.0000	1			
Lid Rib Assembly, Aft (350 Basket)												

Location Loc Qty Loc Code

WA	2	
58193	2	

58587 → ①

D4086-210		Manufactured	No			140	Each	4.0000	1			
Placard, Max Load												

Location Loc Qty Loc Code

ST112	4	
56978	4	

B 58926

~~7~~
1 886/05/20

Thursday, May 13, 2010 11:10:03 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

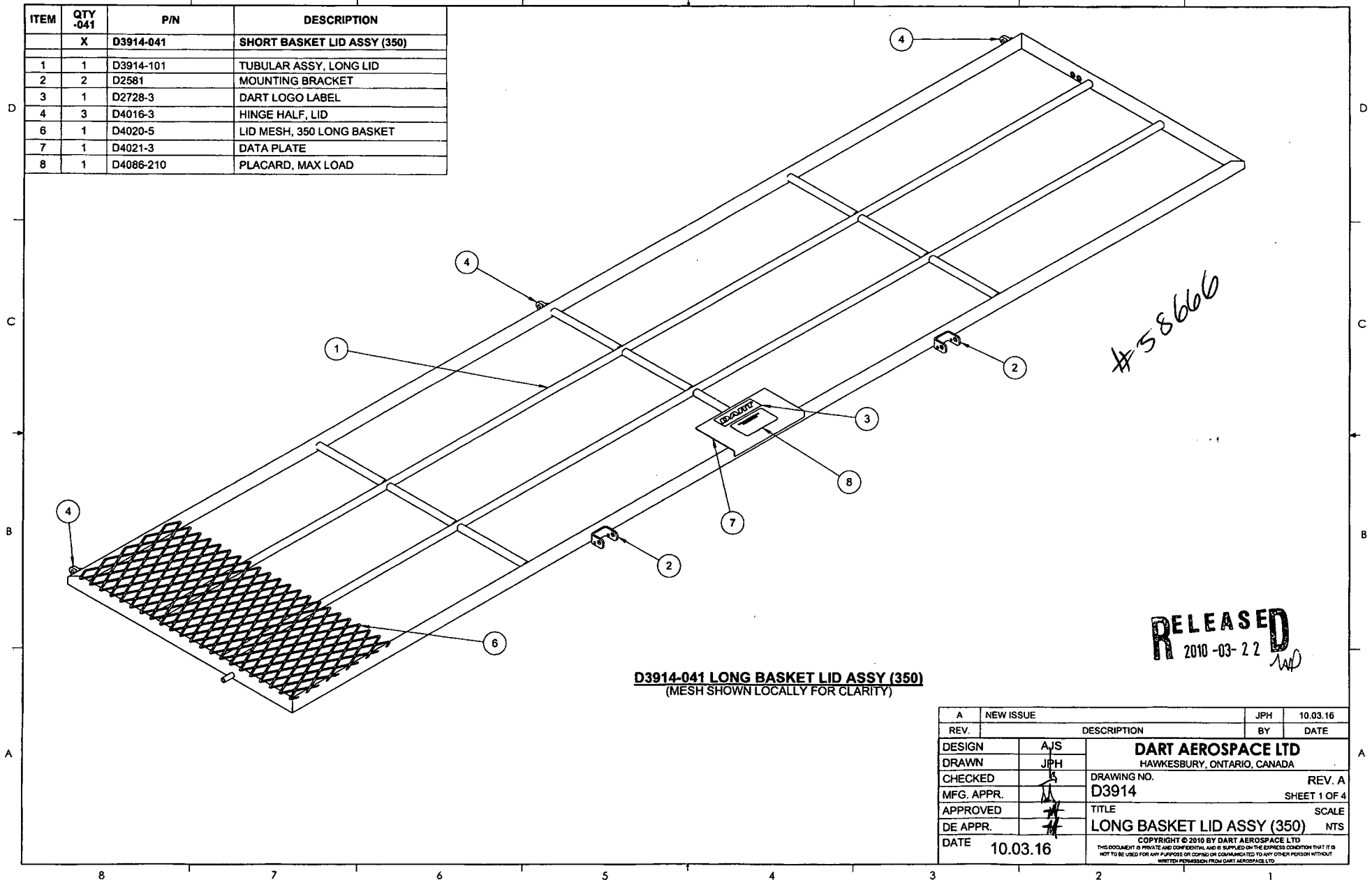
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



RELEASED
2010-03-22

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D3914	REV. A SHEET 1 OF 4
TITLE LONG BASKET LID ASSY (350)		SCALE NTS	
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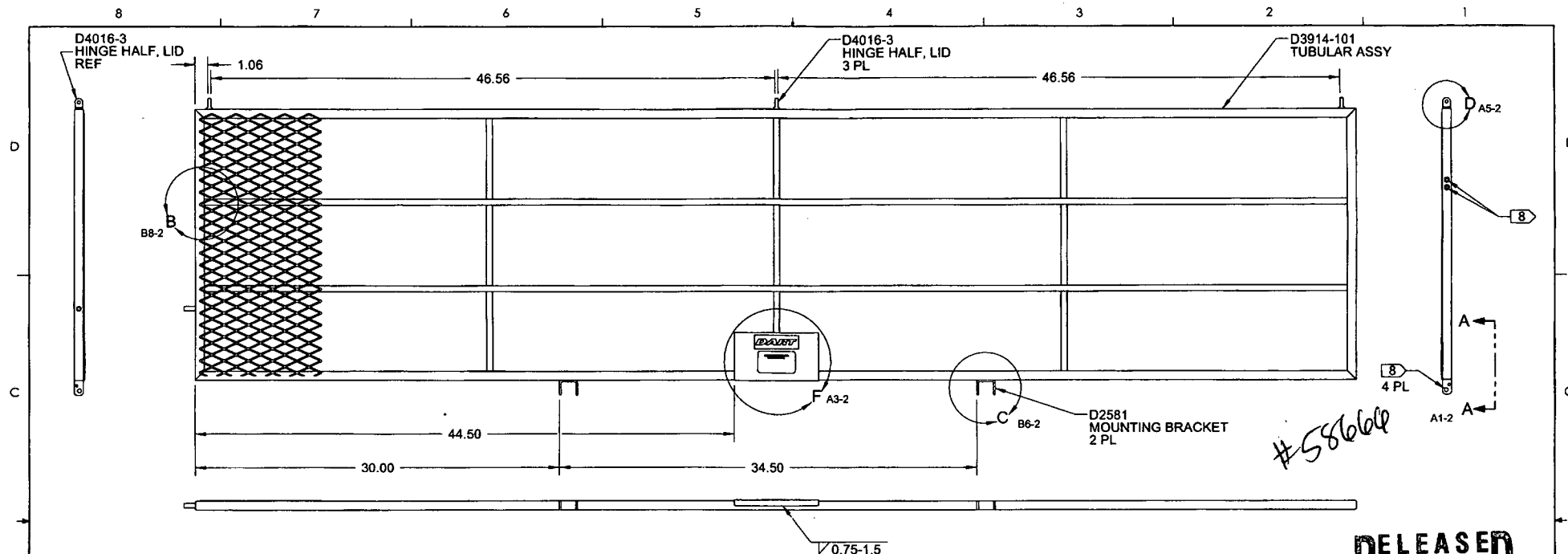
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

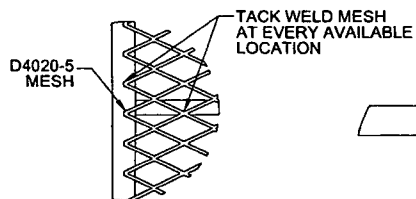
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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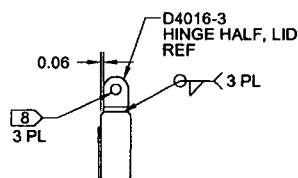
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



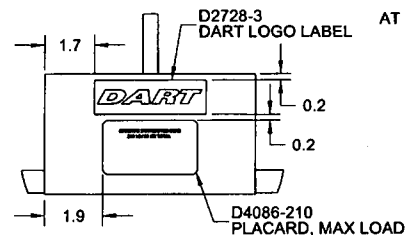
DETAIL B D8-2



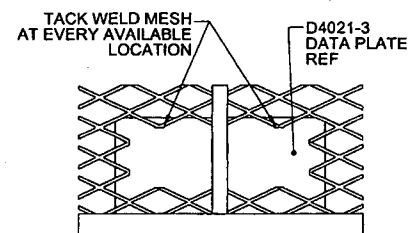
DETAIL C C3-2



DETAIL D D1-2



DETAIL F C4-2



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2010-03-22

#58666

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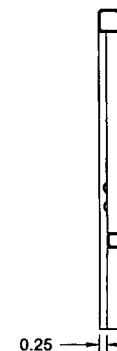
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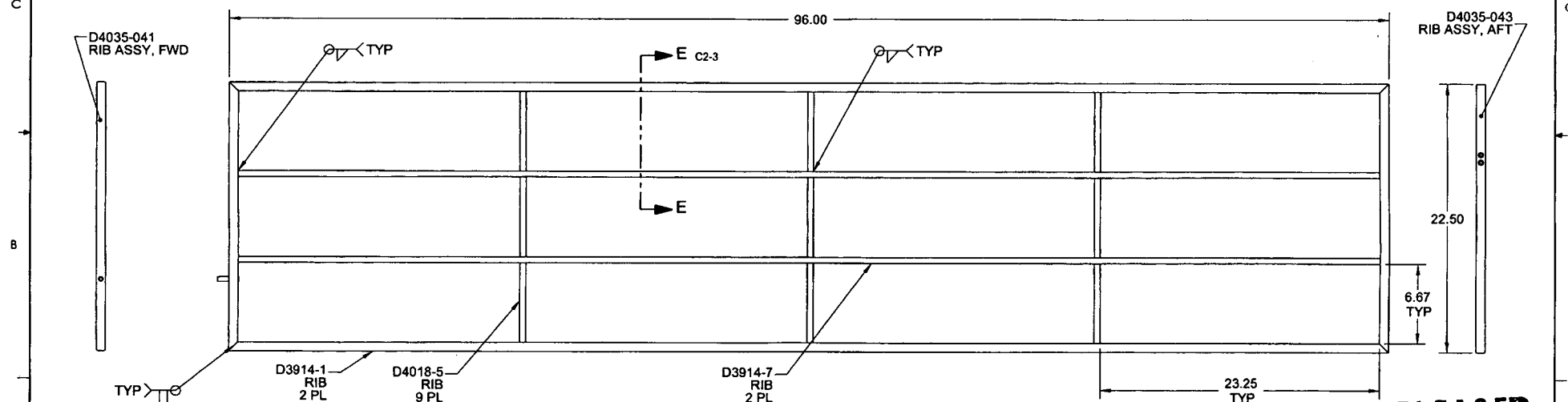
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D3914	REV. A
MFG. APPR.		TITLE LONG BASKET LID ASSY (350)	SHEET 3 OF 4
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
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2010-03-22

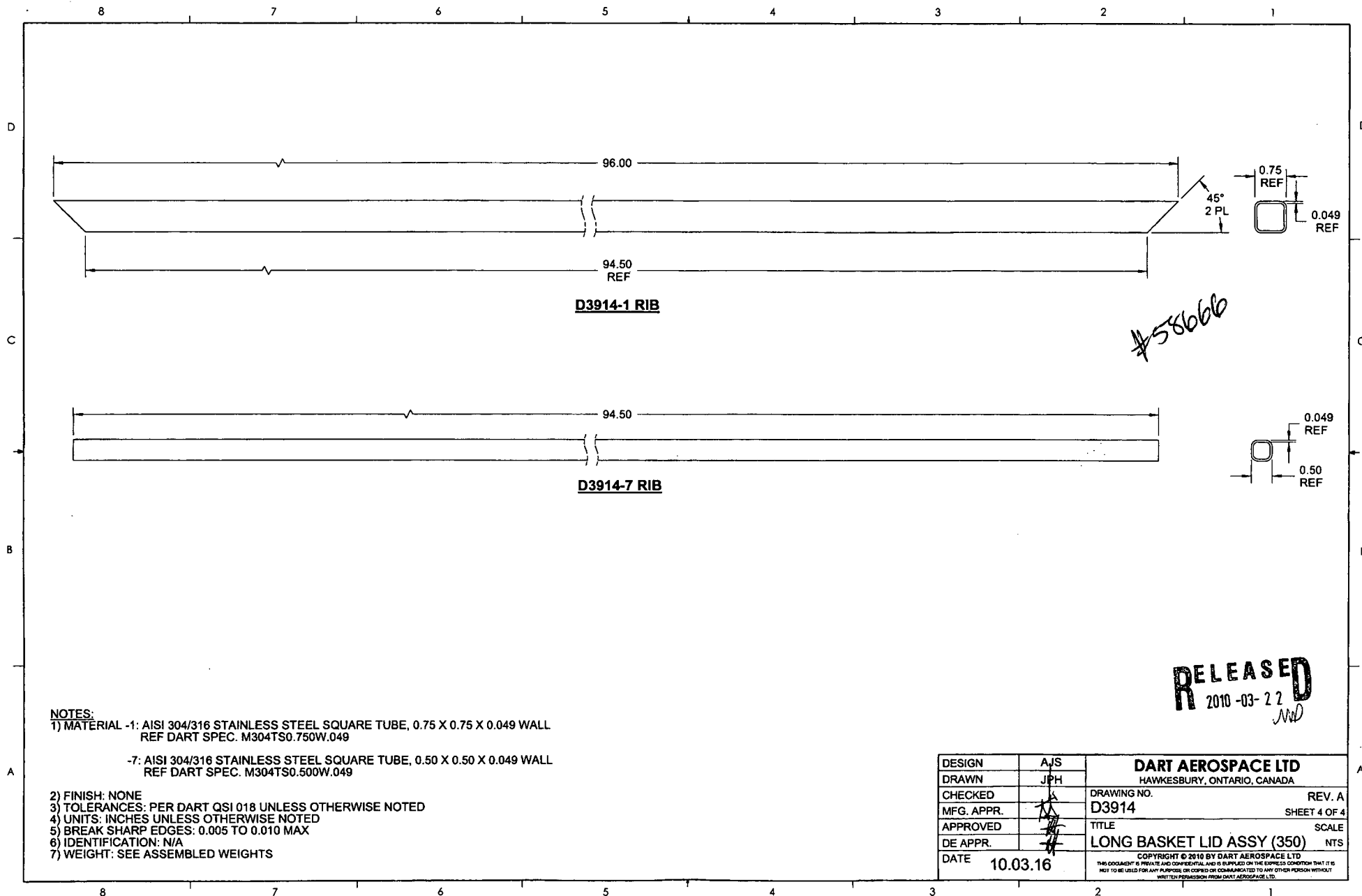
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